

014527



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2873-043
Job Sheet 205961



Part No: D2873-043

Job Qty: 40 pcs

Part Name: Nut Plate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/21/20

Job Tracking No:

Due Date: 3/10/20

Created By: Marie Lajeunesse

Type: Stock *Sold*

Description:

Note: DWG REV A IPP A 05.09.13 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier	Lead Time	Sign-off
					Setup Hrs	Run Hrs			
100	Bandsaw - 1	40 pcs			0.00	0.19	Bandsaw - 1	<i>52</i> <i>9-89</i>	<i>20/07/29</i>
110	HAAS 4 Axis - B4B	40 pcs			0.04	10.55	HAAS - 1 - B4B	<i>52</i> <i>9-89</i>	<i>20/07/29</i>
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	40 pcs			0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51	<i>52</i> <i>9-89</i>	<i>20/07/29</i>
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



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CANADA
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Container No: S251894



Part: D2873-043

Job No: 205961

Serial No/Batch: S251894

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/29/20

			QC 2 - 63	
			QC 2 - 8	
			QC 2 - 66	
			QC 2 - 64	
			QC 2 - 65	
			QC 2 - 5	
			QC 2 - 71	
			QC 2 - 73	
			QC 2 - 69	
			QC 2 - 76	
130 QC 8	40 pcs	0.00 0.00	QC 8 - 12	
			QC 8 - 14	20/01/29
			QC 8 - 17	
			QC 8 - 20	
			QC 8 - 25	
			QC 8 - 3	
			QC 8 - 32	
			QC 8 - 33	
			QC 8 - 35	
			QC 8 - 39	
			QC 8 - 4	
			QC 8 - 44	
			QC 8 - 45	
			QC 8 - 49	
			QC 8 - 58	
			QC 8 - 8	
			QC 8 - 9	
			QC 8 - 68	
			QC 8 - 67	
			QC 8 - 1 (A)	
			QC 8 - 47	
			QC 8 - 40	
			QC 8 - 52	
			QC 8 - 23	
			QC 8 - 57	
			QC 8 - 76	
			QC 8 - 61	
150 QC 5	40 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
160 Handfinish - 1-1 Chemical-B4B	40 pcs	0.00 0.50	Handfinish - 1 - 1 - B4B	
			Handfinish - 1 - 2 - B4B	
			Handfinish - 1 - 3 - B4B	JAN 30 2020

			Handfinish - 1 - 4 - B4B	
			Handfinish - 1 - 5 - B4B	
			Handfinish - 1 - 6 - B4B	
			Handfinish - 1 - 7 - B4B	
			Handfinish - 1 - 8 - B4B	
			Handfinish - 1 - 9 - B4B	
			Handfinish - 1 - 10 - B4B	
			Handfinish - 1 - 11 - B4B	
			Handfinish - 1 - 12 - B4B	
			Handfinish - 1 - 13 - B4B	
			Handfinish - 1 - 14 - B4B	
			Handfinish - 1 - 15 - B4B	
			Handfinish - 1 - 16 - B4B	
			Handfinish - 1 - 17 - B4B	
			Handfinish - 1 - 18 - B4B	
			Handfinish - 1 - 19 - B4B	
			Handfinish - 1 - 20 - B4B	
			Handfinish - 1 - 21 - B4B	
			Handfinish - 1 - 22 - B4B	
170 QC 7	40 pcs	0.00 0.00	QC 7 - 10	
			QC 7 - 13	
			QC 7 - 14	
			QC 7 - 15	
			QC 7 - 17	
			QC 7 - 18	
			QC 7 - 19	
			QC 7 - 2	
			QC 7 - 28	
			QC 7 - 3	
			QC 7 - 30	
			QC 7 - 34	
			QC 7 - 36	
			QC 7 - 37	
			QC 7 - 41	
			QC 7 - 47	
			QC 7 - 48	
			QC 7 - 51	
			QC 7 - 58	
			QC 7 - 59	
			QC 7 - 60	
			QC 7 - 9	
			QC 7 - 68	
			QC 7 - 50	
			QC 7 - 67	
			QC 7 - 40	
			QC 7 - 24	
			QC 7 - 43	
			QC 7 - 61	
			QC 7 - 81	FEB 03 2020
			QC 7 - 76	
			QC 7 - 79	
			QC 7 - 83	
180 Small Fab - 2 - B4B	40 pcs	0.00 1.36	Small Fab - 1 - B4B	
			Small Fab - 2 - B4B	
			Small Fab - 3 - B4B	
			Small Fab - 4 - B4B	FEB 19 2020
			Small Fab - 5 - B4B	
			Small Fab - 6 - B4B	
			Small Fab - 7 - B4B	

190 QC 5	40 pcs	0.00 0.00	Small Fab - 8 - B4B	
			Small Fab - 9 - B4B	
			Small Fab - Various 1 - B4B	
			QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	MAR 23 2020 40 9-89
			QC 5 - 61	
			QC 5 - 81	
200 Packaging 3-1 - Stock - B4B	40 pcs	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	DAS 74 LG050 MAR 23 2020 9-89
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	

1/21/2020

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

210 QC 21 - SA		40 pcs	0.00 0.00	Packaging 3 - 37 - B4B	
				QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	MAR 2 2020

Part Op 100 - Cut blanks: 1.000" x 0.375" x 3.700" long
 Descriptions: 110 - (HAAS CNC Vertical Machine) Machine as per Folio FA and Dwg D2873 Identify as D2873-3 Dwg Rev A Folio Rev AA
 120 - (QC2- Inspect parts off machine FA/FAIB)
 130 - (QC8- Inspect parts - second check)
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - (Chemical Conversion Coat per QSI005 4.1)
 170 - (QC7-Inspect Chemical Conversion Coat)
 180 - 1-Assemble as per Dwg D2873 2-Identify as D2873-043
 190 - (QC5- Inspect part completeness to step on W/O)
 200 - (Identify as per dwg & Stock Location: _____) LOCATION : LG050
 210 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.375X1.000	6061T6 Bar .375 X 1.00	12.3320 ft (.3083 ea)	100-Bandsaw - 1	<u>S25063</u>
MS20426AD4-6	Rivet	<u>522</u> 240 Ea (6 ea)	180-Small Fab - 2 - B4B	<u>S235269</u>
MS21075L5	Nut Plate	<u>261</u> 120 Ea (3 ea)	180-Small Fab - 2 - B4B	<u>S256564</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B0.375X1.000	12	17	0
180-Small Fab - 2 - B4B	MS20426AD4-6	240	1,689	0
	MS21075L5	120	208	0

Part Specifications	
Specifications could not be found.	

Plex 1/21/20 1:15 PM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 205961
Description: Radius Block		Part Number: D2873-3
Inspection Dwg: D2873	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.50	✓		Ver	B17321454
2.000	+/-0.010	2.000	✓		"	"
0.750	+/-0.010	0.749	✓		"	"
1.000	+/-0.010	1.000	✓		"	"
0.250	+/-0.010	0.249	✓		"	"
1.000	+/-0.010	1.000	✓		"	"
2.000	+/-0.010	2.000	✓		"	"
3.000	+/-0.010	3.000	✓		"	"
Ø0.128	+0.005/-0.001	Ø.129	✓		G.P.	Ref.
0.359	+/-0.010	0.359	✓		Ver	"
Ø0.316	+0.006/-0.001	Ø.318	✓		G.P.	Ref.
1.000	+/-0.010	0.999	✓		Ver	"
0.250	+/-0.010	0.250	✓		"	"
0.061	+/-0.010	0.063	✓		"	"
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	Ø.230 x .125	✓		G.P + Ver.	" + Ref.

Measured by: DAS 52	Audited by: [Signature]	Prototype Approval:	N/A
Date: 9-89 20/1/28	Date: 20/01/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM	[Signature]

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		Other/Details: _____ _____ _____			